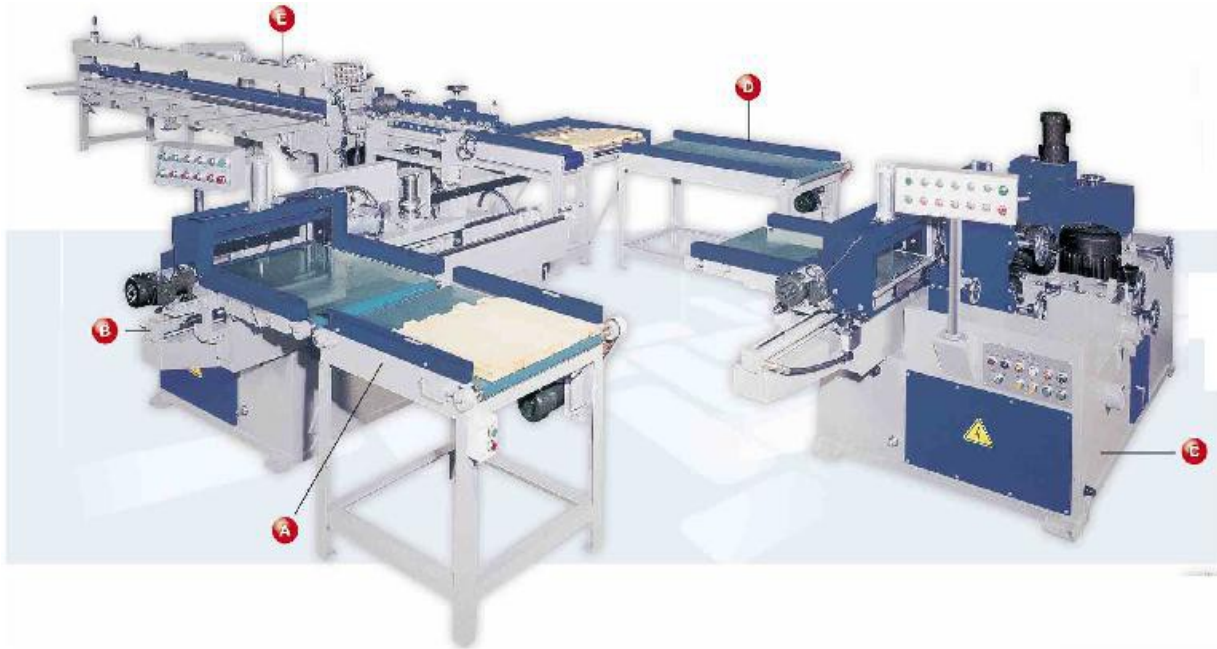
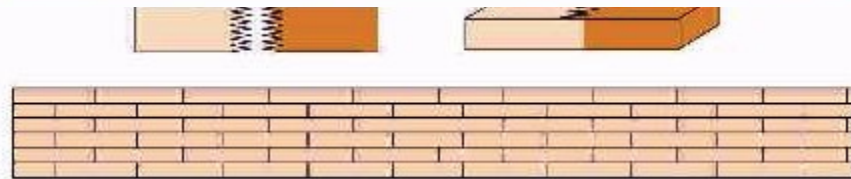




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|--|---|
| A. ONE TABLE MATERIAL STORAGE BELT CONVEYOR | D. STORAGE & PUSHER DEVICE |
| B. 1ST FINGER JOINTER SHAPER MACHINE | E. HIGH-SPEED CHAIN STORAGE CONVEYOR |
| C. 2ND FINGER JOINTER SHAPER MACHINE | F. FINGER JOINTER COMPOSER(4.6M OR 6.2M) |



SFJ-8-181-AUTO-ST 8" X 181" Auto Finger Joint Line

Features:

- The fully automatic finger joint production line complete with the SFJ-610 Right Hand Shaper, SFJ-610G Left Hand Shaper and SFJ-4500C Assembler to produce the mass finger joint stocks.
- The SFJ-610 performs end trimming and shaping functions on right end of sticks.
- The SFJ-610G performs end trimming shaping & gluing functions on left end of sticks.
- The two trim saws are fitted with one saw blade for cutting even end of stick, and one blade for tip breaking ensuring a great jointing result.
- Air-operated clamp comes down to hold sticks firmly in place. After workpiece is clamped, table starts to feed, performs trimming and shaping operations.
- The shaper spindle is precision constructed for cutting finger shapes accurately and accommodates a maximum cutter diameter up to 6".
- The spindle height adjustment is displayed on a dial readout gauge for easy adjustment.
- The table travels on a precision linear motion guide.

- The table traverse is driven by hydraulic power system, ensuring very stable, smooth workpiece feeding. Thus, an accurate, fine cutting result is guaranteed.
- Once the SFJ-610 finishes the cutting then the conveyor table will automatically transfer the sticks to SFJ-610G and come back to the start position for accepting new sticks for work right away.
- In the meantime, once SFJ-610G completes its work, the sticks will auto transfer for inspection then be sent to SFJ-4600B for assembly press to finish the cycle.
- The SFJ-4600B is a very efficient automatic machine that performs three functions, jointing of sectional sticks which have been glued, cutting the jointed sticks to desired length, final assembly is securely pressed by powerful hydraulic system, then the jointed sticks can be feed out regularly.
- Auto power feeder for fast feeding and auto stops at the length to be cut.
- Furnished with cutting off saw as standard equipment for cutting workpieces to the length desired.
- The maximum length of jointed stick is 16'. Other sizes are available upon request.
- The machine employs an advanced programmable logic controller for easy operation and maintenance.
- The machine's motion sequences are displayed by the signal lamps for easy checking in the event of a malfunction.

Machine Base Specifications:

Machine configured for planing, finger sharpening, glue and press joint for manufacturing wood boards. Feed through machine with the right and left gluer shaper and press supported by heavy sheet-metal base.

- Work Thickness: 3/4" ~ 6"
- Work Length: 8" ~ 31"
- Finish Press Work Width: 3/4" ~ 6"
- Finish Press Work Thickness: 3/4" ~ 3"
- Max. Finish Press Length: 181"

Machine Specifications:

Stock Transfer Conveyor Unit (One Unit): The conveyor receives the material and transfers to the right hand finger shaper.

- Table Width: 24"
- Table Depth: 30"
- Motor: 1/2 HP

SFJ-610 Right Hand Finger Shaper Unit (One Unit): The unit to scroll, trim and shaper the finger at right side of material.

- Max. Width: 24"
- Working Length: 7" ~ 31"
- Max. Thickness: 6"
- Hogging Saw Motor: 5 HP x 1
- Scoring Saw Motor: 1 HP x 1
- Shaper Motor: 20 HP
- Shaping Speed: Variable, Max 2.5 Times / Min
- Feed Belt Motor: 1/2 HP
- Hydraulic Motor: 2 HP
- Dust Hood Outlet: 4" x 3

SFJ-610G Left Hand Finger Shaper Unit (One Unit): The unit to scroll, trim, shapes the finger and applies the glue to the left side of material.

- Max. Width: 24"
- Working Length: 7" ~ 31"
- Max. Thickness: 6"
- Hogging Saw Motor: 5 HP x 1
- Scoring Saw Motor: 1 HP x 1
- Shaper Motor: 20 HP
- Shaping Speed: Variable, Max 2.5 Times / Min
- Feed Belt Motor: ½ HP
- Hydraulic Motor: 2 HP
- Glue Applicator Motor: ½ HP
- Dust Hood Outlet: 4" x 3

Transfer Conveyor Unit: The conveyor receives the material from the finger shaper and transfers to the finger press.

- Table Width: 24"
- Table Length: 40"
- Feed Motor: ½ HP x 1

SFJ-4600B Finger Press Unit: The unit to cut off the ends and presses the material to the maximum 181 inch length.

- Working Width: 3/4" ~ 8"
- Working Thickness: 3/4" ~ 3"
- Max Length: 181"
- Max. Thickness: 3"
- Saw Motor: 3 HP x 1
- Hydraulic Motor: 7 ½ HP x 1
- Dust Hood Outlet: 4" x 1

Voltage: Requirements: 230 or 480V 3PH (only can pre-wire for one of the voltage by request)

Adhesive Media: We warrant only the mechanical performance of our machines. We cannot in any way guarantee or warrant the performance of glue or other cutting media, their life or costs, quality and appearance of machined surfaces, or other factors beyond our control.

(Training and installation, tooling & rigging are optional)
(Customer is responsible for local regulations and connecting utilities)



SFJ-610



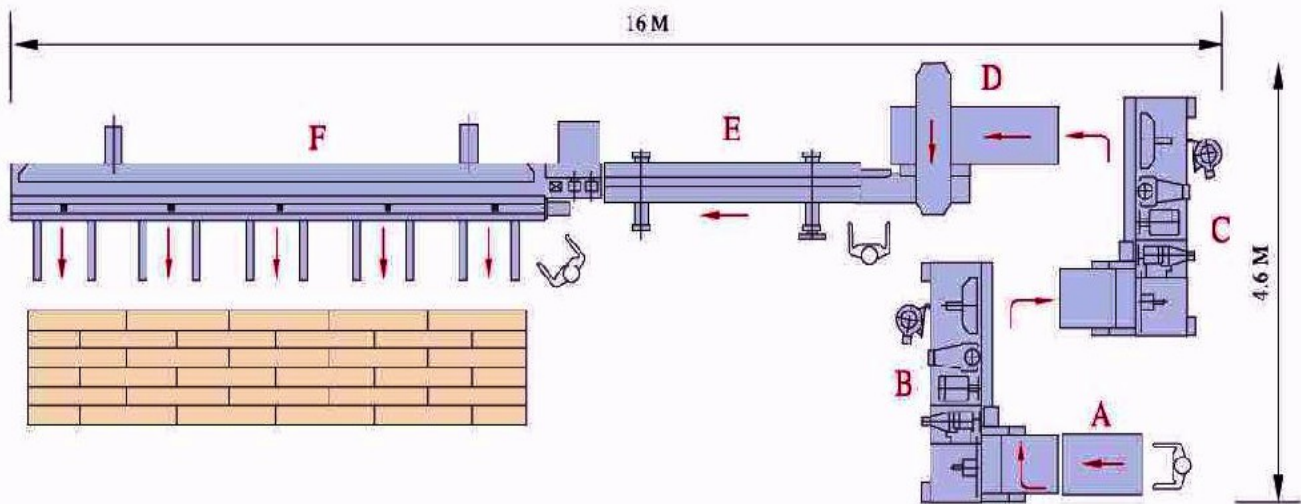
SFJ-610G



SFJ-4600B



FLOW CHART



Finger Jointer Station Detail

Hold Down Press:

1. The Side Press will come in first to align the material first then backward.
2. The Top Press come down to hold the material.
3. The Side Press coming again to firmly hold the material



Saw & Hogging Station:

- Saw blade to cut off the material:
(10" Dia x 100T x 50 mm Arbor)
- Hogging Cutter to chipping the extra material:
(10" x 12T x 1" Arbor)



Shaper Station:

Finger Shaper Cutter to make finger at end of the material.



(Optional: Glue Injection Spreader Station)

Pneumatic action glue injector to apply / spread the glue into the fingers for ready to use finger jointer press.

